

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011917**Date Inspected:** 18-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. An qing xiang/ Mr. Li lin	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower		

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

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1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 042218 perform FCAW welding on, Skin E fit lugs inside East tower, Lift 4, weld joint identified as ESTL4-2 B/L-45, 46. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 049220 perform FCAW welding on, Skin E fit lugs inside East tower, Lift 4, weld joint identified as ESTL4-2 G/L-119. ZPMC CWI Identified as Mr. Li lin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040699/ 044550 perform SAW welding on, CD corner of East tower, Lift 5, weld joint identified as ESD1-TL5- 2B/F-16B. ZPMC CWI Identified as Mr. An qing xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U2B-S.

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4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 053469 perform SMAW tack welding on, AE corner of North tower, Lift 5, weld joint identified as NSD1-TL5- 3B/F-39B. ZPMC CWI Identified as Mr. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3314.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040269 perform SMAW repair welding on, CD corner of North tower, Lift 4, weld joint identified as NSTL4- 3B/L-1 A/B. ZPMC CWI Identified as Mr. Liu zhong an. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)- repair.

6.This QA inspector, Baskar Govindarajan, taken measurements of Flange to flange distance, stiffener to stiffener distance, Bolt hole requirement, 10 mm to CJP distance of 4 struts which is as follows, 1. WD1-A305-77mtr.-4, 2. WD1-A 305-53mtr.-4, 3. WD1-A 305-53 mtr.-3, 4. WD1-A305-65mtr. -3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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